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RBE350A94-2708-01
Job Sheet 197468



67K

Part No: RBE350A94-2708-01 **Job Qty:** 16 pcs
Part Name: Tail Rotor Blade Locking Tool

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 7/9/19 **Job Tracking No:**
Due Date: 9/2/19 **Created By:** Marie Lajeunesse
Type: Stock **Description:**
Note: DWG RBE350A94-2708-01 Rev G IPP Rev A 18.01.23 New issue DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	16 pcs	9/2/19		0.08	3.20	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		<i>GP 19-01-09</i>
110	QC 5	16 pcs	9/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		<i>DAS</i>
							QC 5 - 30		<i>40</i>
							QC 5 - 40		<i>JAN 09 2020</i>
							QC 5 - 61		<i>9-26</i>
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	16 pcs	9/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	16 pcs	9/2/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS
28
9-89

JAN 10 2020

Part Op 100 - (Small Fab) 1-Fabricate lanyard as per DWG. sheet 1 note 7. 2-Assemble as per DWG. sheet 1.
Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location:) Identify and Stock
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	32 Ea (2 ea)	100-Small Fab - 1	215202
90866A030	Wing Nut 5/16" - 18	6 16 Ea (1 ea)	100-Small Fab - 1	172689
CL-2-C	Lanyard Wire	18.5600 ft (1.16 ea)	100-Small Fab - 1	192012
NAS1756-12	Remove Before Flight	6 16 Ea (1 ea)	100-Small Fab - 1	200859
RBE350A94-2708-01-01	Slide	6 16 pcs (1 ea)	100-Small Fab - 1	103797
RBE350A94-2708-01-15	Rod Assembly	6 16 pcs (1 ea)	100-Small Fab - 1	199245 x4
				197863 x2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	32	559	0
	90866A030	16	95	0
	CL-2-C	19	1,252	0
	NAS1756-12	16	154	0
	RBE350A94-2708-01-01	16	6	0
	RBE350A94-2708-01-15	16	0	0

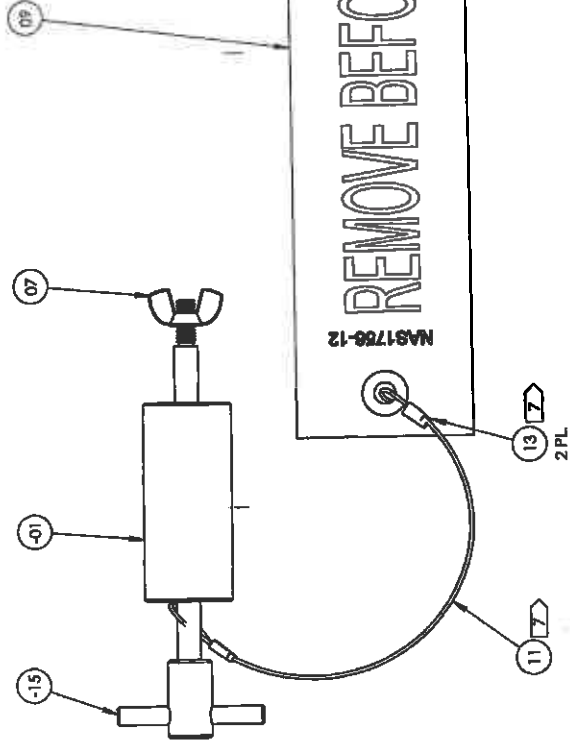
Part Specifications

Specifications could not be found.

Plex 7/9/19 9:21 AM Dart.lajeunesse.marie

ITEM#	QTY	PART #	TITLE
-01	1	RBE350A94-2708-01-01	SLIDE
-05	1	RBE350A94-2708-01-15	ROD ASSY
07	1	McMaster9068A020	WING NUT 5/16"-18
08	1	NAS 1754-12	REMOVE BEFORE FLIGHT
11	AR	CARR-LANE PCL-2-C or McMaster248T144	LANYARD 1/8" NYLON COATED
13	2	McMaster306T31	FERRULE 1/8" DIA. x 3/8"

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
4	-01 CHD DIM WAS 0.492 IS 0.492 0.49 X 0.07 0.49 CHD P.F. IS 0.3116 TO 0.312 P.F. -05, CHD FINISH WAS BLACK ANODIZE IS BLADE OXIDE	-	3/10/2014	DPD	QE
5	-13 ADDED TO BOM, ADDED MISSING DIM 2X .88 TO SHT 1.	15-0211	8/14/2015	RUC	JAG
6	UPDATED TO NEW STANDARDS -03 CHD THREAD CLASS WAS 2B IS 2A, CHD DIM WAS 0.3122/3116 THRU P.F. -06 IS 0.3122/3116 THRU ALL (P.F. -05), ADDED FINISH SPEC.	16-0258	12/5/2016	SM	JAG
6	ASSY -15 ADDED & DIMENSION 2X .88 REMOVED, TEMPLATE UPDATED, NAME ADDED TO CARR-LANE DESCRIPTION, ASSY NOTE ADDED	17-504	01/02/2018	VM	ML



REMOVE BEFORE FLIGHT
NAS1754-12

REMOVE BEFORE FLIGHT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197468 MJS
13-07-09

RBE350A94-2708-01 TAIL ROTOR BLADE LOCKING TOOL

- NOTES:
- 1) MATERIAL: N/A
 - 2) MATH TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) CRIMP FERRULES ONTO 12" LONG LANYARD AS SHOWN

TITLE		TAIL ROTOR BLADE LOCKING TOOL	
PART NO.	RBE350A94-2708-01	REV.	G
FOR THE RECORD (DO NOT REMOVE)			
DESIGNED BY:	VM 01/02/2018	YOUR SIGNATURE	
DRAWN BY:	VM 01/02/2018	DATE & TIME	
INFO REVIEWED BY:	DD 01/03/2018	BY	
APPROVED BY:	ML 01/03/2018	SCALE: NTS	1 SHEET OF 4
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



NCR No. _____

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QSI042)					
Description Work Order Deviation		Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Completed By			
								Lead hand / Supervisor	
								QC / QA Coordinator	